

Date: Tuesday, 07/04/2009 10:22:49 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER ADAPTER FLANGE
<b>Job Number</b> : 46989	
<b>Estimate Number</b> : 12310	
<b>P.O. Number</b> :	<b>Part Number</b> : D34775
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3477 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46217	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JWD 09.04.07</u>	
<b>Comment</b> : Est Rev:A New Issue 06-03-03 JLM	
Est Rev:B 09-02-13 rev.b as per dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



**Comment:** Qty.: 0.1817 sf(s)/Unit Total : 0.7266 sf(s)

304/316 0.018 SHEET

Batch: 109398 B9-4-28  
B9-4-27

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET

Cut as per Dwg D3477

Dwg Rev: B B9-4-28  
B9-4-27

Prog Rev: SAB

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 016428 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.



B9-4-27  
B9-4-28

2-Form as per Dwg D3477 using Dt8858 A,B&C

FF 09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3477-5 PAR #: N/A Fault Category: Prod/Asy <sup>med & small</sup> NCR: (Yes) No DQA: (D) Date: 09/05/05  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: (N) Date: 09/05/06

NCR: <u>46989</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/14/07	2.0	Found that all 6 parts have inside dia measuring 3.600" Dwg Asks For 3.40" Rev B R/L Dwg. is at <del>change</del> B		Scrap And Repe B2 109398	HB 9/4/04	S 09/04/05		S 09/04/07
		FAI sheet is @ Rev A. And Program never updated. - operator measures off FAI sheet.		up Date FAI sheet.				S 09/04/07

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:22:49 AM

User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER ADAPTER FLANGE

Job Number: 46989

Part Number: D34775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/05

(78)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 104

9/5/5

Sg

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05

JD

Job Completion



mrf  
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

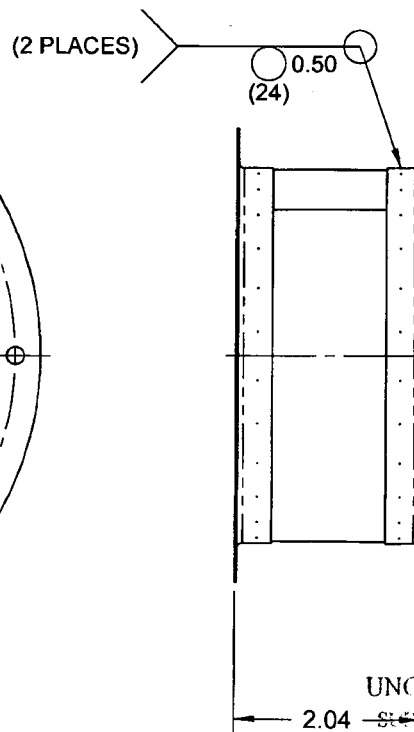
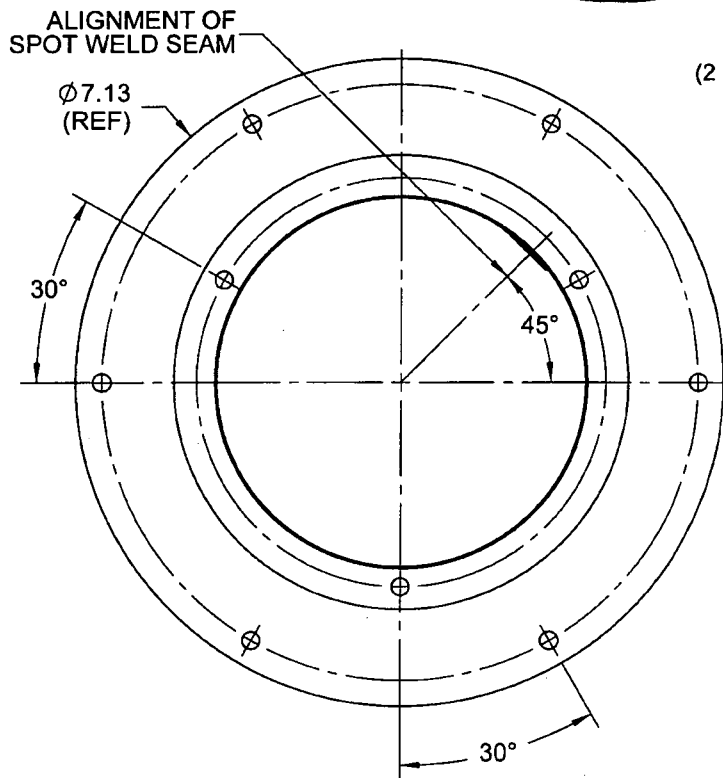
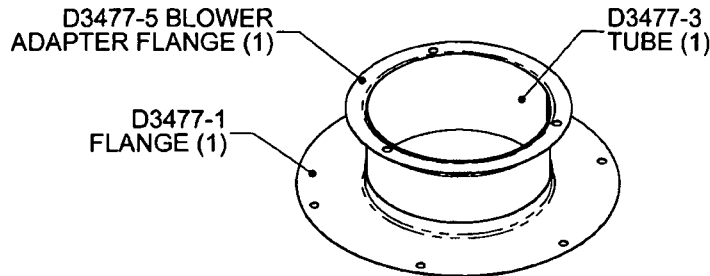
**NOTE:** Date & initial all entries





DESIGN 	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. <b>D3477</b>	REV. B SHEET 1 OF 4
DATE <b>08.12.19</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2
A	05.12.09	NEW ISSUE	
B	08.12.19	$\phi 3.40$ & $\phi 4.1$ WERE $\phi 3.600$ & $\phi 4.14$ (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL-S-5019	

**RELEASED**  
8/01/30



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40989

### D3477-041 BLOWER MOTOR INLET ADAPTER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

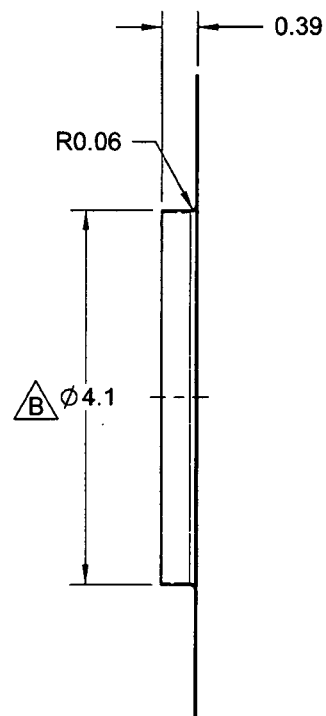
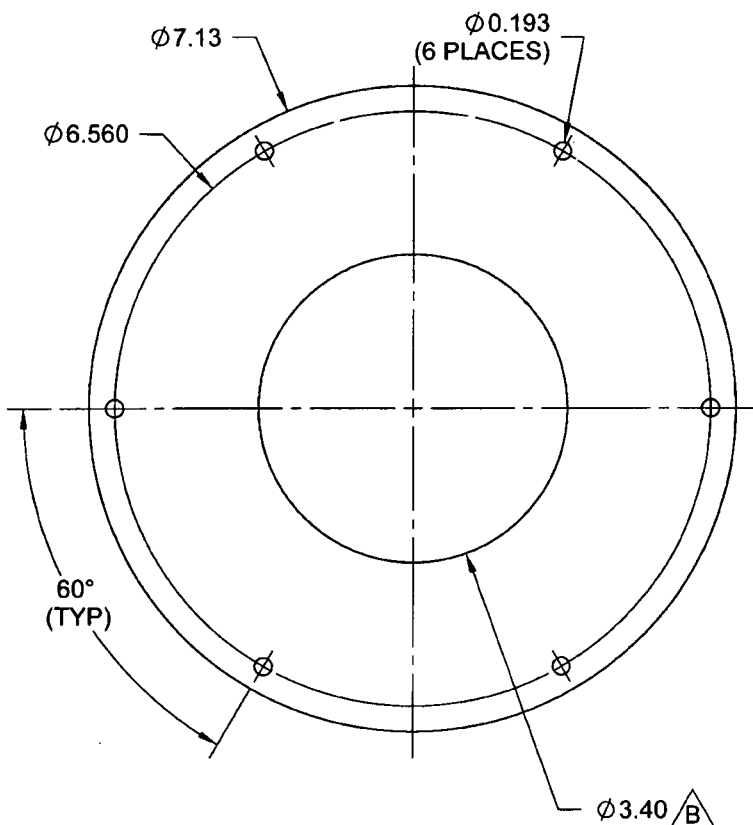
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
9/2/20 M



**D3477-1F FLANGE  
FLAT PATTERN**

**D3477-1  
FLANGE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
NO. 46989

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

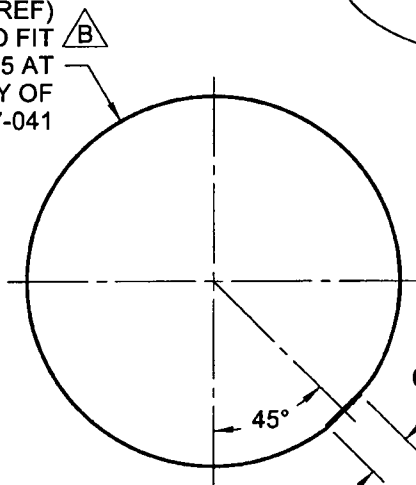
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>h</i>	DRAWN BY <i>h</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>pt</i>	APPROVED <i>h</i>	DRAWING NO. D3477	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
9/12/2019

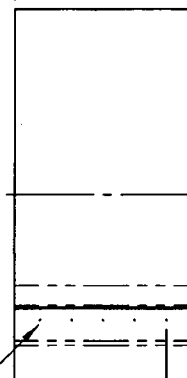
Ø4.10 (REF)  
FORM TO FIT  
D3477-1/-5 AT  
ASSY OF  
D3477-041



0.50<sup>+0.10</sup><sub>-0.00</sub> B

45°

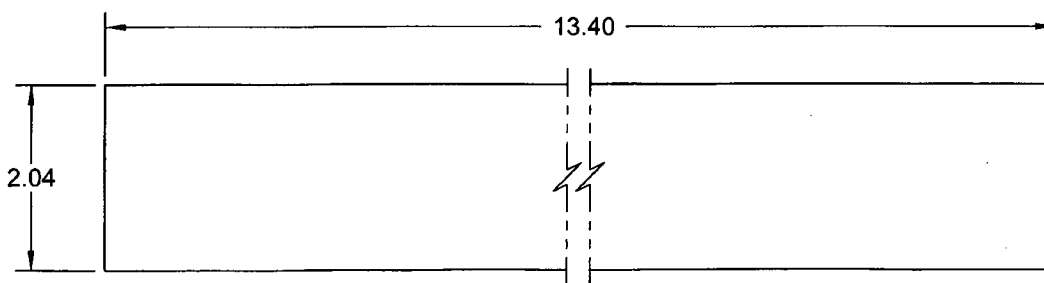
2.04  
(REF)



0.35

0.38  
(5)

### D3477-3 TUBE



### D3477-3F TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

REFLECT TO  
ORIGINAL

INVENTORY COPY  
SEE B TO ADJUDICATE

WARRANTY

NO. 46987

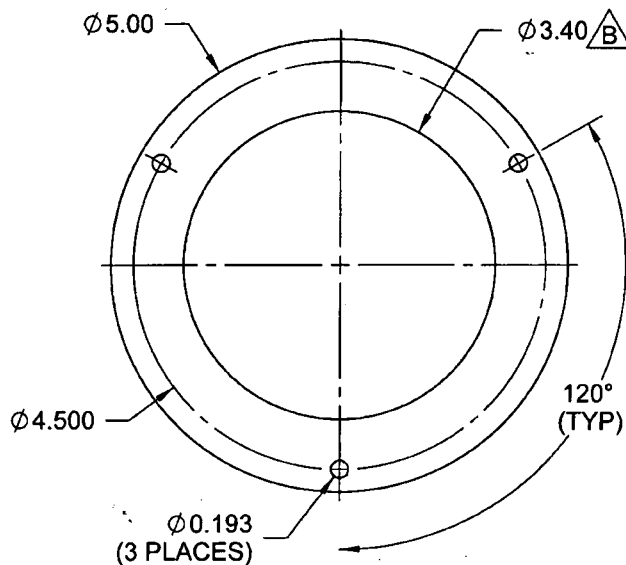
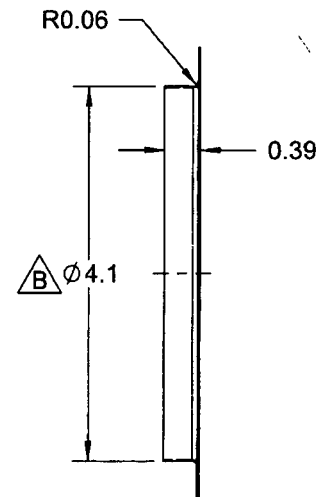
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3477</b>	REV. B SHEET 4 OF 4
DATE <b>08.12.19</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**RELEASED**  
*[Signature]***D3477-5F FLAT PATTERN****D3477-5 BLOWER  
ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

RETURN TO

ENGINEERING  
UNCONTROLLED COPY

SUBMIT TO A

WITH

NO. *46989*

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.